

Date: Wednesday, 12/12/2007 11:36:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPRING CLIP ASSEMBLY
Job Number : 36272	
Estimate Number : 10645	
P.O. Number : N/A	Part Number : D2429041
This Issue : 12/12/2007 S.O. No. : N/A	Drawing Number : D2429 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/12/2007 Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 29025	Material : N/A
Written By : <u>JA</u>	Due Date : 12/19/2007 Qty: 20 Um: Each
Checked & Approved By : <u>07.12.12</u>	
Comment : Est. D 02.03.06 Added note at step 7 NG	
Est Rev:E Now on Waterjet 06-06-13 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



4047



Comment: Qty.: 0.0071 sf(s)/Unit Total : 0.1428 sf(s)

304/316 .040 Sheet

(M304S040)

Batch: 105871 1807-12-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2429

*****Make 2 parts per -041 assembly*****

Dwg Rev: C1

Prog Rev: C1

1807-12-12

2-Deburr if necessary

57

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



1807-12-12



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 07/12/12 57

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2429-1 as per Dwg D2429

57 07 12/20

57

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/12/2007 11:36:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 36272

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
7/12/20 (28)

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part number
1 MS20470AD4-5

Description Batch
Rivet M104156

FF 07-12-20 (28)

8.0

AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part number Description Batch
2 AN960JD6L Washer

M5519

FF 07-12-20 (28)

NOTE: 2 D2429-1 required for 1 assy.

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

FF 07/12-21 28

10.0

QC5

INSPECT WORK TO CURRENT STEP



one D2429 left over
574



Comment: INSPECT WORK TO CURRENT STEP

7/12/24 (28)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 33

7/12/24 500 (28)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

28/10/03

Job Completion



min 2006/1/2 W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

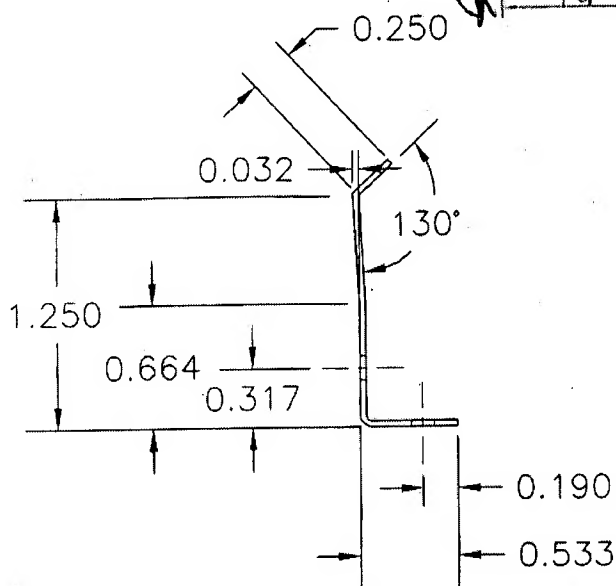
NOTE: Date & initial all entries

DART

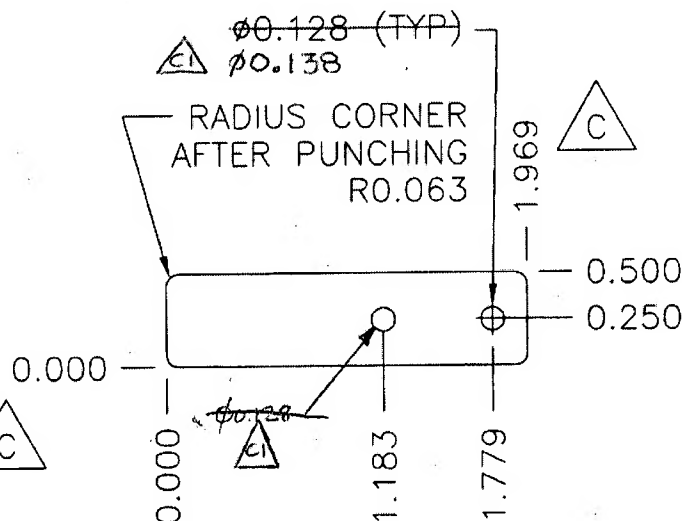
COPY ISSUED

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26		TITLE SPRING CLIP	SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	01.03.27	Ø 0.138 WAS Ø 0.128	

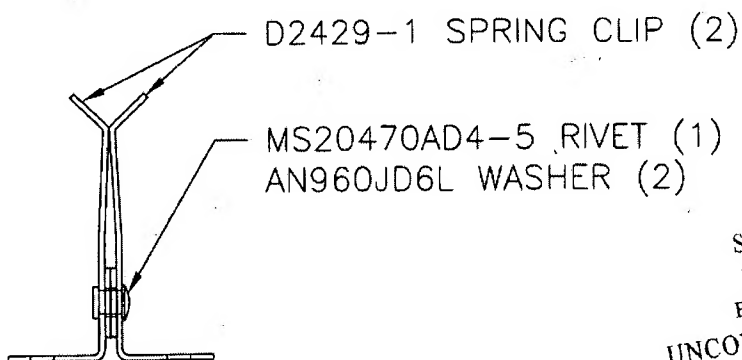
RELEASED
00.06.27



D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN



D2429-041 SPRING CLIP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36272

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

